

10/530622

METHOD FOR MONITORING AND ANALYSING A PROCESSClassification of the Invention

5 The present invention relates to a method for monitoring and analysing a production process, in which method

a large number of variables are measured from the process,

with the aid of these variables, a fingerprint
10 according to a good process situation, relative to runnability, is defined in at least two sub-processes and is then stored in a memory,

the stored fingerprints are compared with fingerprints obtained in a normal process situation,

15 on the basis of the comparison, the difference, displayed graphically to the user, in each sub-process, between the recorded good situation and the momentary process situation is defined.

20 Background of the Invention

Learning neural networks can be used to effectively classify large amounts of data and to reveal connections and groupings in measurements and large masses of data, which are very
25 difficult to find using statistical analysis, mathematical models, or logical rules. International patent publication WO 01/75222 discloses a method, exploiting a neural network, for monitoring a paper production process and gives references to the general literature on neural networks. According to
30 experience, the method disclosed by the publication can be used to reveal a process moving away from the optimal zone, well before problems appear in the form of, for example, a web break. The electrochemical measurements are preferably carried out using equipment according to publication WO 01/25774.

However, the use of the known method will not determine the cause of a problem very quickly, even if, when an index deviation occurs, the input variables of the neural network are examined. Often, the cause is not a matter of deviation in a single input variable, but rather of a detrimental combination of several variables.

In practice, it has been observed that quite many problem situations are always associated with similar circumstances.

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Summary of the Invention

The present invention is intended to create a new type of method in a production process, by means of which the process can be monitored more easily and accurately than previously. The characteristic features of the invention are stated in the accompanying Claims. The point of departure of the invention is to seek the causes of problems as quickly as possible. From the point of view of the invention it was important that the differences detected were due to quite specific problems. Such specific problems appear, for instance, in a paper machine in the following contexts:

- mass mixing in the short circulation
- condition of felts in the press section
- 25 - water equilibrium in the felts
- electrochemical state in the wet end
- total retention
- drying process
- process state during change of grade
- 30 - 'runnability quality' monitoring - breaks, holes, and spots.

To a considerable extent, the phenomena are machine-specific. For these situations, it is possible to record narrow-area fingerprints of a negative situation.

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In one paper machine, it was noticed that the press-section felts could become clogged to a considerable extent, without this immediately interfering with production. This fault situation will not, however, stand an additional disturbance, 5 as the absorptive capacity of the felts will be insufficient, if additional absorptive capacity is required, due to the additional disturbance. In such a situation, processes are added to monitor specific, machine-specific special indices, which define the delimited unwished-for situations to be 10 detected in the sub-processes. In this manner, mass mixing that is detected to be poor, a certain electrochemical state, and the condition of the felts in the press section are monitored, and connected, if necessary to the alarm system of the process. There is often time to correct such a problem, as factors 15 disturbing running accumulate only over several hours.

Preferably, each process, for example a paper machine, is divided into sub-processes, the method according to publication WO 01/75222 being applied to each sub-process.

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Preferably, the output vectors of each neural networks are processed to create a scalar or other single-valued variable for each index. Poor fingerprints can be detected not only by a neural network, but also using simpler logical circuits, 25 because they often have quite precisely defined criteria. However, the best result is usually obtained using a neural network, if a search is made for a negative fingerprint, even though there are only a few input variables. Process phenomena are often non-linear.

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A multi-level perceptron neural network (MLP), which functions particularly well in online conditions, is preferably used in the method. In the learning stage, it is quite possible to use a Back Propagation network, for example.

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Other advantages and embodiments of the invention will be described later in connection with the examples of applications.

5 Brief Description of the Drawings

In the following, the invention is examined in greater detail with reference to the accompanying drawings, in which

Figure 1 shows the general arrangement of the method according
10 to the invention, in connection with a paper machine

Figure 2 shows the steps in the structure of the measurement data of a paper machine

Figure 3 shows the information hierarchy of a paper machine

Figure 4 shows equipment according to the invention, in a
15 paper-machine environment.

Detailed Description of the Invention

In Figure 1, a paper machine is shown schematically, and
20 includes a short circulation 1, a head box 2, a wire section 3, a press section 4, a dryer section 5, and reeler section 6. Naturally, the units at the beginning of a paper machine have a greater effect on its runnability than the units at the end. The runnability index of each component can be formed in the
25 manner disclosed in publication WO 01/75222. In addition, it also uses the indices of two poor fingerprints.

In one paper machine, the negative effect of a particular mass mix has been detected. This can be recognized quite easily,
30 even directly from the existing measurements results. This can be linked to an alarm, or the index can be intended to be retrieved, for example, only if the short-circulation index deviates from a good value.

35 In one paper machine, it has been noticed that blockage of the felt causes at least some of the web breaks. However, it is

quite easy to measure the condition of the felt and form an index of it, and even a direct alarm, if the condition index drops below a set limit. The fingerprint of a poor process situation is narrow-area, including at most six input variables. For one felt index, the following data is required:

- the pressure in the pick-up press vacuum-box
- the position of the pick-up press charging-air valve
- the pressure in the 1st press vacuum-box
- the position of the 1st press charging-air valve

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In addition, in the starting stage it is best to use a special start-mix, which will ensure a smooth start-up. After start-up, the mass mix can be changed to be in accordance with the product recipe.

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Similar poor fingerprints can also be recorded from the electrochemical measurements at the wet end, which depict a particular 'taste index'. It has also be surprisingly observed that it is worth taking into account the wet-end electrochemical measurements, when evaluating the quality of the paper produced, even though, in this case, the learning must be carried out in a quite labourious manner. Naturally, it is nearly impossible to measure any electrochemical properties in dry paper, nor does electrochemistry greatly affect the properties of dry paper. However, the situation is different in a printing machine, in which the absorption and spread of ink, for example, depend on the electrochemical properties of wet paper. The paper's dusting, its travel through a printing machine, and the adhesion of printing ink/filler also partly depend on the said electrochemical properties.

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In paper production, electrochemistry affects, in general:

- the surface and colloidal chemistry of the paper
- the structure of the paper
- 35 - sheet formation
- the action of chemical additives

- the dirtying of the paper machine
- the wear of felts/fabrics
- the operation of the doctor blades.

5 As can be seen from the above, the properties of the finished paper depend to some extent on the electrochemical properties of the mass used in its manufacture.

Negative fingerprints are generally based on a rather small
10 group of variables (3 - 6). A good fingerprint, on the contrary, is based on many variables (10 - 20), but the group can often be reduced after the research stage. In other words, when fine-tuning the monitoring and analysis equipment, it is possible to see which variables are less important.

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Individual indices can be made for process variables that must be kept constant (in a paper machine consistencies, pressures, temperatures, 10 - 20 items), making it possible to see immediately if even one breaks away from its set value.

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In practice, the multi-level perceptron (MLP) has proven itself to be the most preferable type of neural network, because it functions excellently in online operation and in a process environment, in which the phenomena are non-linear. In the
25 learning stage, a Back Propagation neural network can preferably be used.

Generally, runnability and quality are kept on target by monitoring the fingerprints of good situations in each sub-
30 process. If a deviation then appears, the cause of the fault or deviation in general will be found considerably faster, if special detection of specific poor fingerprints is available. Monitoring is facilitated by a common runnability index for the entire paper machine, any change in which will indicate a need
35 to search for the sub-process causing the problem.

Figure 2 shows a diagram of the principle of how data from thousands of process measurements are reduced initially to 8 - 16 indices and finally to a single runnability index and a single quality index. The sub-processes short circulation, head box, and wire section form the wet end, in which there are also electrochemical measurements. The press section, dryer section, and reeler (pope) form the dry end of the paper machine. An individual index is formed for each sub-process and a common runnability index for the entire paper machine is formed from them.

In one paper machine, buffing of the felts was observed in a combination, in which a low amount of broke of 7 % (normally 25 %) occurred at the same time as the addition of biocides. Such detrimental combinations can be traced easily by using negative fingerprints. At its simplest, a negative fingerprint is formed from a few state data, using logical circuits (AND, OR, NOT). Usually, neural network is required in this case too, because many process phenomena are non-linear and the use of a neural network is handy, especially in the learning stage (situations in which the process changes).

Figure 3 shows a more detailed hierarchy, related to the invention, of the paper machine's measurement information. 100 - 200 process data are formed from existing measurements of the paper machine (several thousands of I/O inputs) and from the particular electrochemical measurements. For the electrochemical measurements, there is one (head box) or more measurement units 10. In one embodiment, there is one unit for each raw material branch (TMP, mechanical pulp, cellulose, de-linked mass, broke, and circulation water).

The desired sub-process indices, which are marked in Figure 3: Pulp, Raw material, Additive, Electrochemistry (taste), Head box, Wire section, Press section, Felts, Dryer section, and Pope, are formed from the said process data.

An individual data window is formed from these for each operator and specialist. These are the pulp man, the machine man, the automation specialist, the felt supplier, and the chemicals supplier.

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Also marked in Figure 3 are a runnability index, which depicts the operation of the entire paper machine, and a finished paper quality index, which is calculated from the basic indices and from possible ancillary quality measurements. In practice, any
10 deviation in the quality index derived from electrochemistry will cause at least a warning that the printability of the paper and/or the permanence of the filler may be diminished.

Preferably, the indices are calculated from two or more
15 consecutive sub-processes, allowing the cause-effect relationships to be determined. This is exploited in the research stage, for instance, by forming negative fingerprint-indices of unfavourable combinations. In the research stage of the start-up of the system, the set of neural-network input variables can
20 also be reduced considerably.

Figure 4 shows one apparatus according to the invention in a paper machine environment. The system is connected to the existing mill data communications network 20, the data system
25 21, and to the mill workstations 24. The mill system includes, through a sub-network 20.1, the control systems for the wet end (2, 3, 4) and the dry end (4, 5). The system according to the invention collects not only the mill's process information (from the unit 21), but also data from its own electrochemical
30 units 10. For these, a data-link server 22 and an actual neural-network processing unit 23 are connected to the mill network 20. These are quite conventional industrial PC units. The data-link server 22 collects electrochemical data, used in the neural-network processing, from the units 10 and from the
35 mill's process-data unit 21. Thus, the processing unit receives all of its data from the link server 22.

A particular feature of the system are the remote-control units 25, by means of which the neural networks can be controlled and taught remotely. In addition, the measurement units can also be remotely controlled. The remote control is connected through a
5 public data network (Internet), with the aid of a VPN (Virtual Private Network) formed using two-sided firewalls. With the aid of remote control, an expert can quickly resolve process problems and also effectively make changes to the system. Remote control of the measurement units permits the measurement
10 units to be monitored along with the rest of the system. This is particularly advantageous, especially in the start-up stage. Remote control can be used to perform the operations disclosed in the publication WO 01/25774 for calibrating each sensor and setting it correctly. Remote control can be used to set the
15 base level of each electrode, once the polarization curve has been run.

The system according to the invention can be used generally for the monitoring of various industrial process. These include
20 process control in a de-inking plant, and processes in the chemical, mining, and foodstuffs industries, as well as in the cleaning of waste water and the production of clean water.